

Date: Thursday, 15/05/2008 8:09:58 AM  
User: Linda Lacelle

ASAP  
split

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 39277 - 2	
Estimate Number : 13310	
P.O. Number : .	Part Number : D37931
This Issue : 15/05/2008 S.O. No. :	Drawing Number : PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : R & D SM/MED FAB	Drawing Revision : PRELIM
Previous Run : 39251	Material :
Written By :	Due Date : 22/05/2008 Qty: 40 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 08-05-13 new issue DD verified by:	

POSITIVE  
RECALL

38

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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MAT NOT PULLED



Comment: Qty.: 0.5733 sf(s)/Unit Total : 22.9320 sf(s)  
304/316 .040 Sheet  
(M304S20GA)  
Batch: 100997 .050" LB 8-5-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg D3793  
Dwg Rev: PRE  
Prog Rev: PRE

LB 8-5-22

(33)

2-Deburr if necessary LB 8-5-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

LB 8-5-22

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

8 08/05/26 (33)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

see attachment  
mf 08-05-27

8 08/05/27 (33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 15/05/2008 8:09:58 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39277

Part Number: D37931

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Form Joggle on brake using Jig as per Dwg D3793

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08/05/27* (33)  
*counter*  
*08/05/27* (P33)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

*7:30*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*8:00*

*FL/MJ 08/05/28*

(33)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-05-28* (33)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP-16*

*08-05-28* (33)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/05/29*

Job Completion



*MF 08-05-28*

*ACCEPTABLE*  
*RF*  
*08.05.29*

POSITIVE RECALL

EFFECTIVE *08/05/25* AUTH *LI*

RELEASED *08-05-23* DATE *CT*

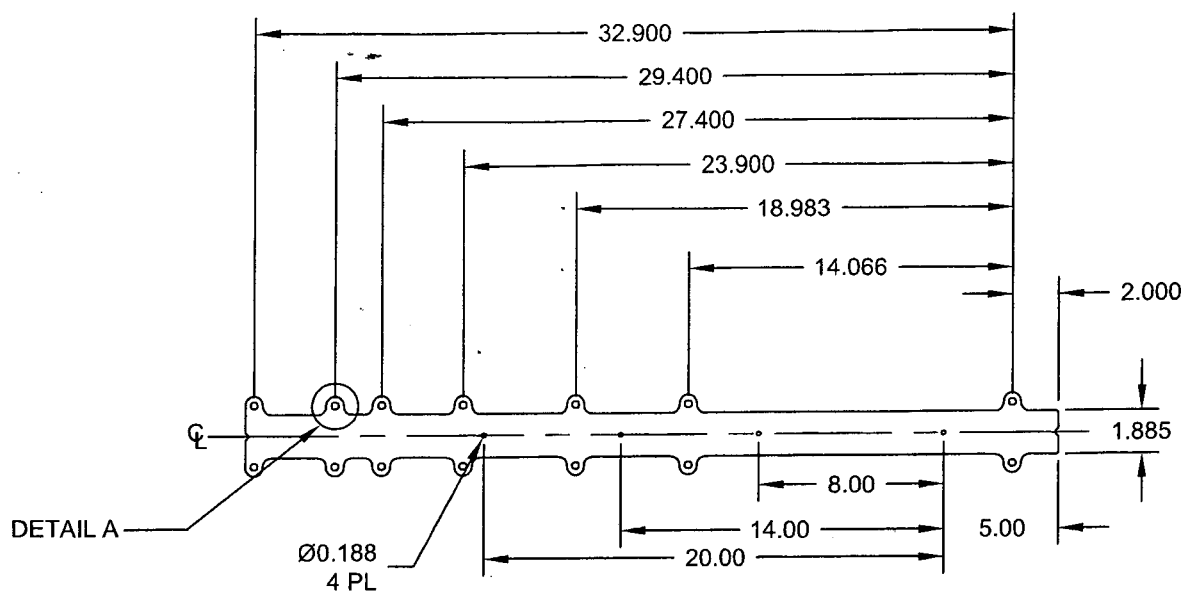
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

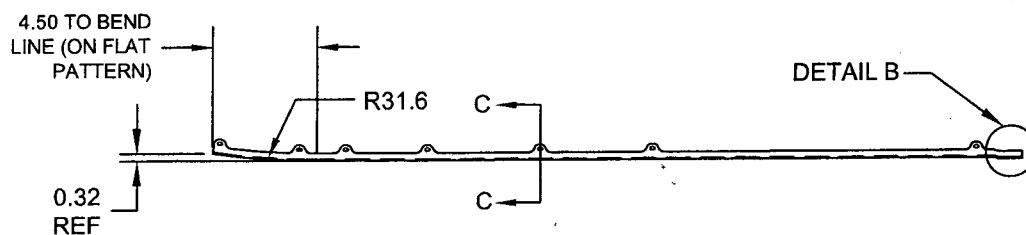
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## D3793-1F FLAT PATTERN



### **D3793-1 BEND DETAIL**

(MAKE FROM D3793-1F)

409277

**NOTES:**

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

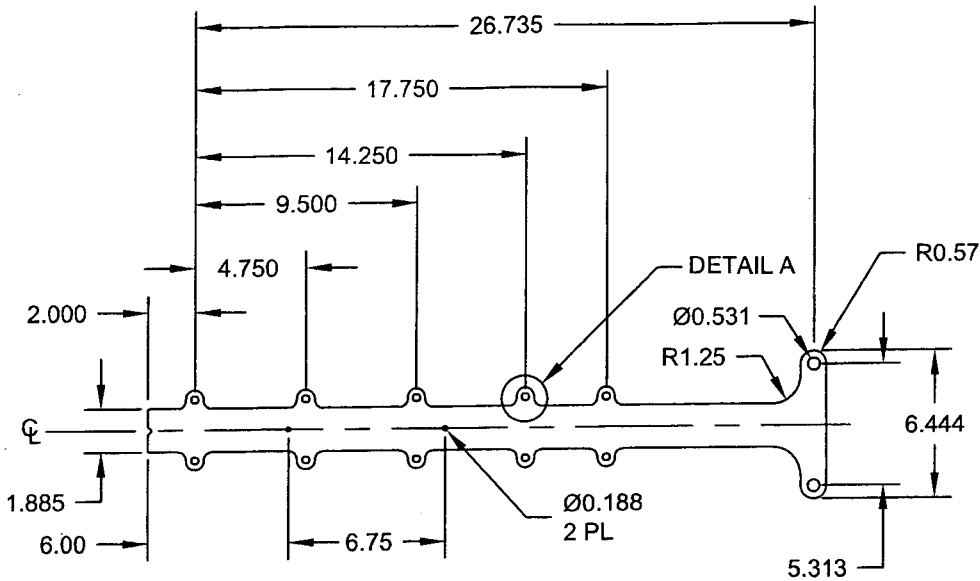
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3793-3F FLAT PATTERN**

**PRELIMINARY ISSUE**  
PH 03.05.15



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

W/O 39277

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

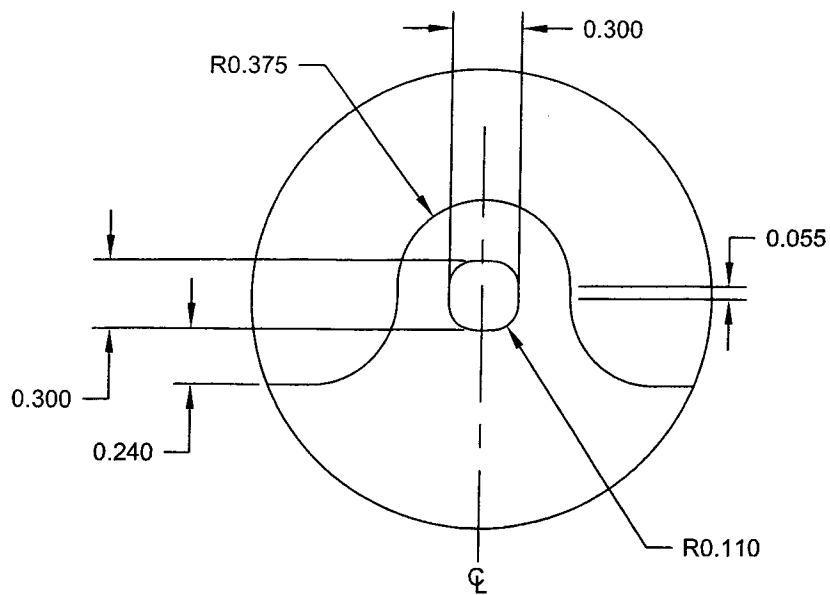
8

7

6

5

D

0.04  
JOGGLI

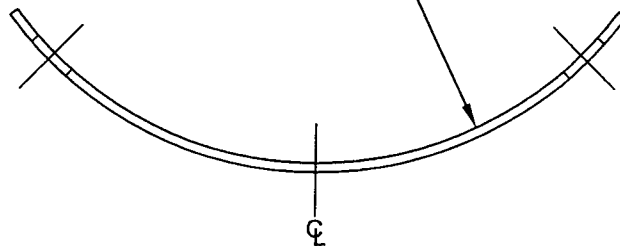
C

**DETAIL A**  
SCALE 10X

*Wb 39277*

B

R1.620



**SECTION C-C**  
SCALE 10X

A

8

7

6

5





Date: Tuesday, 27/05/2008 7:49:27 AM  
User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 39277		
Estimate Number	: 13310		
P.O. Number	:	Part Number	: D37931
This Issue	: 27/05/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: PRELIM
First Issue	: 15/05/2008	Project Number	: N/A
Previous Run	: 39251	Drawing Revision	: PRELIM
		Material	:
Written By	:	Due Date	: 22/05/2008
Checked & Approved By	:	Qty:	40 Um: Each
Comment	: Est Rev:A 08-05-13 new issue DD verified by:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

3-Form Joggle on brake using Jig as per Dwg D3793

SA 08105/24  
08/05/27 (33)

Job Completion



REFERENCE ONLY



### **D3793-1 BEND DETAIL**

(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)



RELEASED  
08-25-23-18

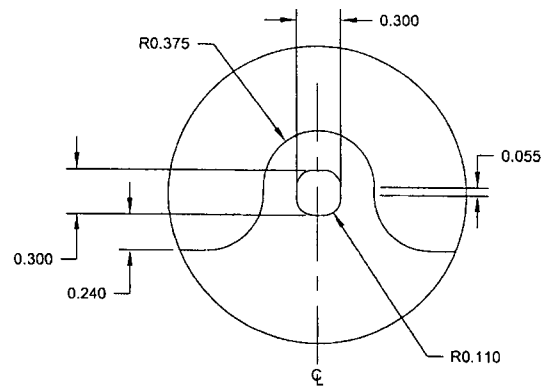
u/o 39277

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH MARK P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

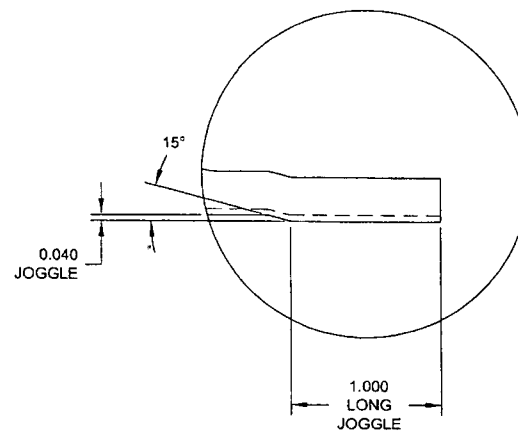
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DRAWN	PH			
CHECKED				
MFG. APPR.	<del>PH</del>			
APPROVED	<del>PH</del>			
DE APPR.	<del>PH</del>			
DATE	08.05.14			

8 7 6 5 4 3 2 1

D



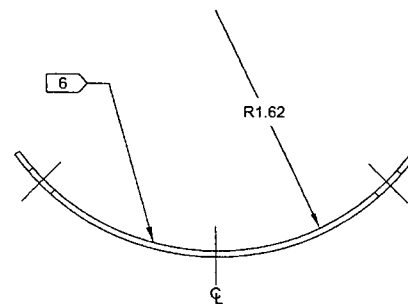
**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X

C

B



**SECTION C-C**  
SCALE 10X

**RELEASED**  
08-05-23/102

ULO 39277

A

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
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8 7 6 5 4 3 2 1